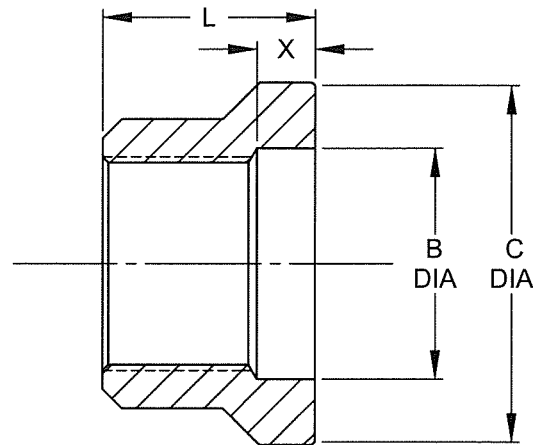
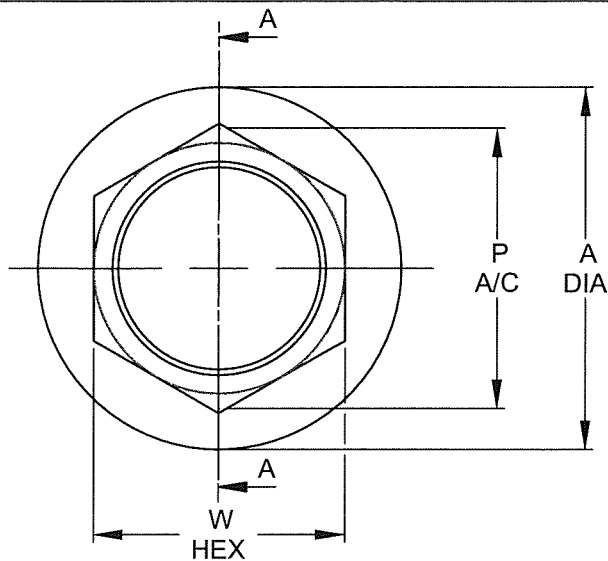




SECTION A-A

DASH NO.	THREAD SIZES	A DIA	B DIA	C DIA MIN	L MAX	X	P A/C REF	W HEX	UTS LBS. MIN	BREAKAWAY TORQUE IN-LBS MIN	LOCKING TORQUE IN-LBS MAX	SEATING TORQUE IN-LBS MAX
3	.1900-32 UNJF-3B	.330 .326	.212 .208	.296	.280	.123 .117	.277	.251 .243	4500	2.0	12	50
4	.2500-28 UNJF-3B	.425 .421	.272 .268	.391	.348	.132 .126	.348	.313 .305	8500	3.5	17	130
5	.3125-24 UNJF-3B	.538 .532	.340 .334	.502	.438	.144 .138	.419	.376 .367	13300	6.5	35	250
6	.3750-24 UNJF-3B	.649 .642	.403 .397	.612	.482	.144 .138	.561	.502 .492	20416	9.5	40	420
7	.4375-20 UNJF-3B	.740 .730	.466 .460	.700	.568	.162 .156	.631	.564 .553	27600	14.0	60	675
8	.5000-20 UNJF-3B	.860 .850	.528 .522	.820	.618	.162 .156	.766	.690 .679	34000	18.0	85	1000
9	.5625-18 UNJF-3B	.915 .905	.598 .592	.875	.678	.176 .168	.837	.752 .741	44000	24.0	110	1250
10	.6250-18 UNJF-3B	.995 .985	.661 .655	.955	.743	.176 .168	.906	.814 .803	55000	32.0	130	1550

GENERAL NOTES:

1. DIMENSIONS APPLY AFTER FINISH.
2. W AND P DIMENSIONS APPLY PRIOR TO DEFORMATION FOR SELF-LOCKING FEATURE.

MATERIAL:

6AL-4V TITANIUM PER AMS4982 OR AMS4967

MAX SERVICE

TEMP:

350°F

HEAT TREAT:

SOLUTION TREAT AND AGE PER PS4061.

PROCUREMENT

SPECIFICATION:

HS394

FINISH:

HLN259AP- () = HI-KOTE® 1 ALUMINUM COATING PER HI-SHEAR SPEC. HS294 AND CETYL-ALCOHOL LUBRICATION PER HI-SHEAR SPEC. HS305

CODE:

DASH NUMBER INDICATES NOMINAL THREAD SIZE IN INCREMENTS OF 1/16 INCHES.

EXAMPLES:

HLN259AP-4 = 1/4 INCH NOMINAL HI-LOK® NUT, COATED WITH HI-KOTE® ALUMINUM COATING

DATE	BY	TITLE	DRAWING NO.
DRAWN 11-04-09	J HULL	HI-LOK® NUT	HLN259
APPROVED 11-17-09	I KOMSITSKY	6AL-4V TITANIUM 1/16" GRIP VARIATION, 160 KSI FOR USE ON STANDARD AND 1/64" OVERSIZE BOLTS	
REVISION			